

FORM PTO-1390 (Modified)  
(REV 11-2000)

U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE

ATTORNEY'S DOCKET NUMBER

**TRANSMITTAL LETTER TO THE UNITED STATES**  
**DESIGNATED/ELECTED OFFICE (DO/EO/US)**  
**CONCERNING A FILING UNDER 35 U.S.C. 371**

19349-089160

U.S. APPLICATION NO (IF KNOWN, SEE 37 CFR

10/069184

INTERNATIONAL APPLICATION NO.  
PCT/CA00/00954 ✓INTERNATIONAL FILING DATE  
16 August 2000 ✓

PRIORITY DATE CLAIMED

16 August 1999 ✓

TITLE OF INVENTION

METHOD FOR FORMING A FASCIA ASSEMBLY FOR A MOTOR VEHICLE ✓

APPLICANT(S) FOR DO/EO/US

Yustick, Robert F. ✓

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (24) indicated below.
4. ☒ The US has been elected by the expiration of 19 months from the priority date (Article 31).
5. ☒ A copy of the International Application as filed (35 U.S.C. 371 (c) (2))
  - a. ☒ is attached hereto (required only if not communicated by the International Bureau).
  - b. ☒ has been communicated by the International Bureau.
  - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☒ An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)).
  - a. ☐ is attached hereto.
  - b. ☒ has been previously submitted under 35 U.S.C. 154(d)(4).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3))
  - a. ☐ are attached hereto (required only if not communicated by the International Bureau).
  - b. ☒ have been communicated by the International Bureau.
  - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
  - d. ☐ have not been made and will not be made.
8. ☐ An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)).
10. ☐ An English language translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)).
11. ☒ A copy of the International Preliminary Examination Report (PCT/IPEA/409).
12. ☒ A copy of the International Search Report (PCT/ISA/210).

**Items 13 to 20 below concern document(s) or information included:**

13. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
14. ☒ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
15. ☐ A **FIRST** preliminary amendment.
16. ☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
17. ☐ A substitute specification.
18. ☐ A change of power of attorney and/or address letter.
19. ☐ A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821 - 1.825.
20. ☐ A second copy of the published international application under 35 U.S.C. 154(d)(4).
21. ☐ A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4).
22. ☒ Certificate of Mailing by Express Mail
23. ☒ Other items or information:
  1. check (\$930)
  2. return postcard

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR 101.101) <b>10/069184</b>		INTERNATIONAL APPLICATION NO. <b>PCT/CA00/00954</b>		ATTORNEY'S DOCKET NUMBER <b>19349-089160</b>																	
24. The following fees are submitted: <b>BASIC NATIONAL FEE ( 37 CFR 1.492 (a) (1) - (5) ) :</b> <input type="checkbox"/> Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO ..... <b>\$1040.00</b> <input checked="" type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO ..... <b>\$890.00</b> <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO ..... <b>\$740.00</b> <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) paid to USPTO but all claims did not satisfy provisions of PCT Article 33(1)-(4) ..... <b>\$710.00</b> <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) ..... <b>\$100.00</b> <b>ENTER APPROPRIATE BASIC FEE AMOUNT =</b>				<b>CALCULATIONS PTO USE ONLY</b>																	
Surcharge of <b>\$130.00</b> for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (e)).				<b>\$890.00</b>																	
<table><tr><td>CLAIMS</td><td>NUMBER FILED</td><td>NUMBER EXTRA</td><td>RATE</td></tr><tr><td>Total claims</td><td>7 - 20 =</td><td>0</td><td>x \$18.00</td></tr><tr><td>Independent claims</td><td>1 - 3 =</td><td>0</td><td>x \$84.00</td></tr><tr><td colspan="3">Multiple Dependent Claims (check if applicable).</td><td><input type="checkbox"/></td></tr></table>				CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	Total claims	7 - 20 =	0	x \$18.00	Independent claims	1 - 3 =	0	x \$84.00	Multiple Dependent Claims (check if applicable).			<input type="checkbox"/>	<b>\$0.00</b>	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE																		
Total claims	7 - 20 =	0	x \$18.00																		
Independent claims	1 - 3 =	0	x \$84.00																		
Multiple Dependent Claims (check if applicable).			<input type="checkbox"/>																		
<b>TOTAL OF ABOVE CALCULATIONS =</b>				<b>\$890.00</b>																	
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27). The fees indicated above are reduced by 1/2.				<b>\$0.00</b>																	
<b>SUBTOTAL =</b>				<b>\$890.00</b>																	
Processing fee of <b>\$130.00</b> for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (f)).				<b>\$0.00</b>																	
<b>TOTAL NATIONAL FEE =</b>				<b>\$890.00</b>																	
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) (check if applicable).				<input checked="" type="checkbox"/> <b>\$40.00</b>																	
<b>TOTAL FEES ENCLOSED =</b>				<b>\$930.00</b>																	
				<b>Amount to be: refunded</b>																	
				<b>charged</b>																	
a. <input checked="" type="checkbox"/> A check in the amount of <del>\$930.00</del> to cover the above fees is enclosed.																					
b. <input type="checkbox"/> Please charge my Deposit Account No. _____ in the amount of _____ to cover the above fees. A duplicate copy of this sheet is enclosed.																					
c. <input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. <b>50-1759</b> A duplicate copy of this sheet is enclosed.																					
d. <input checked="" type="checkbox"/> Fees are to be charged to a credit card. <b>WARNING:</b> Information on this form may become public. <b>Credit card information should not be included on this form.</b> Provide credit card information and authorization on PTO-2038.																					
<b>NOTE:</b> Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.																					
SEND ALL CORRESPONDENCE TO:																					
<div>Robin W. Asher Clark Hill PLC 500 Woodward Avenue Suite 3500 Detroit, MI 48226-3435 (313) 965-8300</div> <div> SIGNATURE  Robin W. Asher NAME  41,590 REGISTRATION NUMBER  2/11/02 DATE</div>																					

12/pst

WO 01/12411

PCT/CA00/00954

METHOD FOR FORMING A FASCIA ASSEMBLY  
FOR A MOTOR VEHICLE

**Field of the Invention**

5        The present invention relates to a method for forming a fascia assembly for a front or rear end of a motor vehicle. In particular, the present invention relates to a method wherein first and second fascia assembly components are fastened together by a molded interlock.

**10    Background of the Invention**

         When manufacturing and assembling fascia assemblies for the front or rear end of a motor vehicle, the exterior fascia panel is usually molded by itself and then connected to other fascia assembly components, such as a bumper beam or a grill and headlamp carrier panel, by fasteners such as threaded bolts. To connect the fascia panel to one of the other  
15    fascia assembly components in such a manner, the panel and the component are typically molded separately and then brought to an assembly station where bores are drilled into the panel and the component. Then, the drilled bores are aligned and bolts are inserted into the aligned bores and securely tightened with nuts to fasten the panel and component together.

20        This conventional approach has two primary drawbacks. First, the conventional approach is relatively inefficient. Specifically, molding the panel and component separately and then bringing them together at an assembly station for fastening is time consuming and occupies manpower and other resources that could be eliminated or more efficiently used elsewhere.

25        The second drawback is that variations in dimensional tolerances between the panel and the component can make it difficult to properly fasten them together using a simple nut/bolt fastening arrangement. That is, when there is misalignment between the holes in the panel and the component, a fastener cannot be easily inserted through the holes. Instead, the holes on either the panel or the component must be widened by further drilling  
30    or the like to ensure that the bolts can pass through the holes. These widened holes are undesirable because, even though they allow the panel and the component to be fastened together, they also allow for relative movement between the panel and the component. This can create visible misalignments when the component is of the kind that is designed to support an exterior structure (e.g., the grill or the headlamps) in a particular orientation  
35    with respect to the fascia panel. Consequently, there exists a need for an improved method of assembling a front or rear end fascia assembly that overcomes these inefficiency and tolerance problems associated with the conventional method.

WO 01/12411

PCT/CA00/00954

# **Summary of the Invention**

It is an object of the present invention to provide a method comprising: (1) molding and solidifying a molten first material so as to form an exterior fascia panel having a first connecting portion integrally molded therewith, and (2) molding and solidifying a molten second material so as to form a fascia assembly component having a second connecting portion integrally molded therewith and molded and solidified to the connecting portion of said exterior fascia panel in an interconnected relationship. The fascia assembly component may be a bumper beam, a pair of transversely spaced apart lamp receiving structures, a carrier panel that mounts the grill and the lamps, a collapsible impact assorting structure, or any other component that connects to the fascia panel.

Connecting the fascia panel and the fascia assembly component in such a manner obviates the need for forming the panel and component separately and then bringing them to an additional assembly station where they would conventionally be secured together using nuts and bolts. Instead, the panel and component are interconnected together by the molded connecting portions. Also, the problems associated with varying dimensional tolerances between the panel and the second fascia assembly component are eliminated because the connecting portions are molded together and are not assembled separately.

It should be understood that the present invention may be practiced using a single mold or using a different mold for each component. A single injection mold using a two-shot process is preferred wherein one molten material is injected into the mold to form either the panel or the component and then another molten material is injected into the mold to form the other of the panel and the component. The use of a single mold is preferred because two operations can be performed at a single station, thereby eliminating costs associated with obtaining and operating an additional mold for the second component.

The order in which the panel and components are molded is also not critical to the principles of the present invention. Either the panel may be molded first or the fascia assembly component may be molded first. In a two-shot, single mold operation the molten material for both the panel and the component may be injected sequentially or simultaneously.

In accordance with a further aspect of the invention, a bore may be formed through the connecting portions of the panel and the fascia assembly component and a pin, a rivet, or other interlocking structure may be inserted through the bore to enhance the interconnection between the two connecting portions. Alternatively, the interlocking structure may be provided as an insert in the mold with the molten material being molded around it as the panel and component are being formed. The use of an interlocking structure is not essential to the principles of the present invention, but enhances the

interconnection between the panel and the fascia assembly component by preventing separation between the connecting portions. When the fascia assembly is installed on the vehicle, the strength of the interconnection is usually not significantly important because the fascia panel and the fascia assembly component will typically be connected to points on the vehicle body or frame and thus an interconnection is not necessary to keep the fascia panel and the fascia assembly component from separating. However, the interconnection between the panel and the second fascia assembly component is relatively important prior to mounting the fascia assembly to the vehicle, especially during transport and handling of the fascia assembly. Thus, this pin, or any other type of interlocking insert, is particularly useful in preventing separation of the fascia panel and the fascia assembly component prior to mounting the assembly on the vehicle.

### Brief Description of the Drawings

Fig. 1 is a perspective view showing a fascia assembly constructed in accordance with the method of the present invention with an exterior fascia panel of the assembly being interconnected with the bumper beam of the assembly;

Fig. 2 is a profile view showing the cross-section illustrated in Fig. 1.;

Fig. 3 is a close-up view showing one of the portions where the fascia panel and the bumper beam are interconnected;

Fig. 4 is a cross-sectional view of an injection molding die assembly used in conjunction with the method of the present invention to perform a two-shot molding operation wherein the bumper beam and the exterior fascia panel are molded and interconnected together;

Fig. 5 is a cross-sectional view of the die assembly taken along line 5-5 of Fig. 4;

Fig. 6 shows the injection molding die assembly of Fig. 5 with a first molten material being injected therein to form the exterior fascia panel;

Fig. 7 shows the injection molding die assembly of Fig. 5 with a second molten material being injected into the assembly to form the bumper beam after the first molten material has been injected as shown in Fig. 6;

Fig. 8 is a perspective view of another fascia assembly constructed in accordance with the method of the present invention with a head lamp receiving can being interconnected with the exterior fascia panel;

Fig. 9 is a cross-sectional view taken along line 9-9 of Fig. 8;

Fig. 10 shows an injection molding die assembly used to mold the assembly of Fig. 8 in a two-shot operation;

Fig. 11 shows another fascia assembly formed using the method of the present invention with a pair of head lamp receiving cans and a grill opening reinforcement

WO 01/12411

PCT/CA00/00954

structure; and

Fig. 12 is a cross-section of yet another fascia assembly formed using the method of the present invention with a series of energy absorbing structures disposed between the panel and the bumper beam.

5

#### Detailed Description of the Preferred Embodiment of the Invention

Fig. 1 shows a perspective view of a fascia assembly for the front end of a motor vehicle formed using the method of the present invention. The fascia assembly is generally indicated at 10. The exemplary fascia assembly 10 shown in Fig. 1 comprises two basic components. These two components are an exterior fascia panel 12 and a rigid bumper beam 14. The exterior fascia panel 12 constitutes a part of and is connected to the vehicle body when the fascia assembly 10 is mounted to the front end of the motor vehicle. The bumper beam 14 is secured by fasteners, welding, or other suitable attachment means to the frame of the vehicle when the fascia assembly 10 is secured to the front end of the vehicle. When the assembly 10 is mounted to the vehicle, the exterior fascia panel 12 conceals the bumper beam 14 from view.

It can be appreciated from Fig. 1 that the fascia panel 12 is provided with a contoured exterior surface 16 that provides the front end of the vehicle with an aesthetic appearance. The preferred material for forming the fascia panel 12 is a thermoplastic that is somewhat flexible when solidified so as to resist denting, such as thermal polyolefin (TPO).

The bumper beam 14 is formed from a rigid material that resists failure/collapse during an automobile impact, such as a glass-filled thermoplastic. The bumper beam 14 is designed to absorb collision impacts when the assembly 10 is mounted to the front end of the motor vehicle. Because the bumper beam 14 is secured to the vehicle frame, during vehicle impacts the forces absorbed by the bumper beam 14 will be transferred directly to the vehicle frame.

It can be best appreciated from Fig. 2 that the exterior fascia panel 12 has a plurality of integrally formed connecting portions 18 (three as shown in Fig. 2) extending rearwardly from the interior surface 20 of the panel 12. Likewise, the bumper beam 14 also has a plurality of integrally formed connecting portions 22 extending forwardly from the front face thereof. These connecting portions 18, 22 are interconnected together as a result of the fascia assembly 10 being constructed in accordance with the method of the present invention. A fastener, rivet, pin, or some other type of interlocking structure 24 may be inserted through the region where the connecting portions 18, 22 of the panel 12 and the bumper beam 14 are interconnected in order to enhance and strengthen the connection between the connecting portions 18, 22.

WO 01/12411

PCT/CA00/00954

Referring to Fig. 3, the connecting portions 18, 22 are shown as overlapping with clean straight lines delineating portion 18 from portion 22 simply to schematically illustrate the connection of connecting portions 18, 22. As will become appreciated from the following description of the method of the present invention, the connecting portions 18, 22 will not be interconnected in such a clean, straight-line manner. Instead, the material defining the connecting portions 18, 22 will run together while melted and solidify together to form a bonded connection between the interconnecting portions 18, 22.

Fig. 4 shows an injection die assembly 30 which may be used to perform the method of the present invention. The injection molding die assembly 30 is a two-shot molding assembly in which two different molten materials can be injected into the die cavity 32. The gates for controlling the flow of the two materials are shown schematically at 34 and 36. The die assembly 30 comprises four die portions, three of which are shown in Fig. 4. The die portions shown in Fig. 4 include a first die portion 38 that provides an interior surface 40 which has a shape corresponding to the shape of the fascia panel's exterior surface 16. A second die portion 42 is provided opposite the first die portion 38 and has an interior surface 44 with a shape corresponding to the shape of the rear face and upper and lower edges of the bumper beam 14. Each of these die portions 38, 42 have a passageway 46, 48, respectively, formed therethrough and opening to the interior surface 40, 44 thereof. These passageways 46, 48 communicate with gates 34, 36, respectively, so that molded material can be injected into the die cavity through the passageways 46, 48.

As best seen in Fig. 5, the die assembly 30 also includes a third die portion 50 and a fourth die portion 52 that are disposed between the first and second die portions 38, 42 when the die assembly 30 is closed and ready for injection. The third and fourth die portions 50 and 52 cooperate to provide a surface 54 that has a shape corresponding to the shape of the interior surface 20 of the fascia panel 12, and a series of surfaces 56 (best seen in Fig. 4) that cooperate to define the portions of the bumper beam's front face that are located between the connecting portions 22. The third and fourth die portions 50, 52 also provide a series of surfaces 58 that cooperate to define portions 60 of the die cavity that extend through the third and fourth die portions 50, 52 between surfaces 54 and 56. As will be appreciated below, these die cavity portions 60 are the areas where the connecting portions 18, 22 are formed, molded and solidified together. Together, surfaces 40, 44, 54, 56, and 58 cooperate together when the die assembly 30 is closed to form a die cavity 62 in which the fascia panel 12 and the bumper beam 14 will be molded and solidified together.

Turning now to Figs. 6 and 7, the method of the present invention will now be described. Fig. 6 shows the mold assembly 30 in its sealed, operative position with all four die portions moved into place. This is accomplished by bringing the third and fourth die portions 50, 52 together in the lateral direction of the assembly 30 (left and right as

WO 01/12411

PCT/CA00/00954

viewed in Fig. 56) and then moving the first and second die portions 38, 42 into sealed operative engagement with the third and fourth die portions 50, 52 to the position shown in Fig. 6. Then, as is conventional in the molding art, a vacuum is applied to draw the air out from the die cavity 62. This prevents bubbles from forming in the final, molded product.

5       Next, gate 34 is opened and a first molten material 64 is injected into the die cavity 62 through passageway 46. This first molten material 64 fills the portion of the die cavity 62 that forms the fascia panel 12 and partially fills the portions 60 that form the connecting portions 18 and 22. It is to be understood that gate 34 is provided to schematically show this first injection step. To better ensure that upper and lower portions of the mold cavity  
10       are filled before portions 60, a pair of gates communicated at the upper and lower ends of the first die portion 38 may be used instead of the single gate 34.

      The first gate 34 is then closed and the second gate 36 is opened and a second molten material 66 is injected into the die cavity 68 through passageway 48. This second material fills the portion of the die cavity 62 that forms the bumper beam 14 and fills the  
15       remainder of the portion 60 that defines the connecting portions 18, 22. Finally, the first and second molten materials 64, 66 are allowed to solidify and the die assembly 30 can then be opened and the fascia assembly 10 can be removed therefrom. It can be appreciated that the first and second molten materials 64, 66 come together in the die cavity portions 60 to form the connecting portions 18, 22. At the area where the  
20       connecting portions 18, 22 meet, the first and second materials 64, 66 intermix and bond together to form an interconnection between the connecting portion 18, 22 when solidified.

      It should be understood that the method of the present invention is not limited to the two-shot method described above. Instead, the fascia panel 12 and its connecting portions 18 may be molded and solidified at one injection molding station and then  
25       brought to a second molding station whereat the panel 12 is placed in a mold and the bumper beam 14 is molded and solidified with its connecting portions 22 molded and solidified to the fascia panel's connecting portions 18.

      With either of these methods, interconnecting structures 24 may be used to enhance the bond between the connecting portions 18, 22. The interlocking structure 24 shown in  
30       Figs. 2 and 3 is driven vertically through all three of the regions where the connecting portions 18, 22 meet after the assembly 10 has been solidified and removed from mold assembly 30 (or the second molding station). Alternatively, individual interlocking structures, such as short cylindrical pins, may be molded into each set of connecting portions 18, 22 by placing the interlocking structures into the mold as inserts. For  
35       example, a series of these short pins could be placed as inserts into the die cavity portions 60 of die assembly 30 and then the molten materials 64 and 66 can be solidified around these pins. To separate the panel 12 and beam 14 for repair or replacement of the panel or



WO 01/12411

PCT/CA00/00954

beam (i.e. if one has been damaged during a collision), the interlocking structure 24 can be removed by drilling or the like to facilitate separation. Once separated, the damaged piece can be repaired and reattached or discarded for recycling.

Another alternative to inserting separate pins or other interlocking structures through the connecting portions 18, 22 is to use a mold insert that provides one of the connecting portions 18, 22 with a T-shape or an L-shape and solidifying that shape and then removing the mold insert before injecting the other material. As the other material is injected into the mold, the other material surrounds the solidified T or L-shape. This enhances the interconnection between the interconnecting portions 18, 22 because the manner in which the second injected material surrounds the T or L-shape provides a firm mechanical connection in addition to bonding between the materials.

It is to be understood that the connection between the panel 12 and the beam 14 is provided to ensure that the panel 12 and beam 14 remain connected to one another until the fascia assembly 10 is assembled to the end of the vehicle. At that point, the panel 12 is fastened to the vehicle body and the beam 14 is fastened to the vehicle frame. The interconnection between the panel 12 and beam 14 does not play a role in keeping together during vehicle operation. Instead, the interconnection serves to keep the beam 14 and panel 12 together as a single unit for delivery to the vehicle assembly site and mounting onto the vehicle end.

After the fascia assembly 10 has been molded according to the method of the invention as described above, the exterior visible components associated with the front end of the vehicle (or the rear end if this were a rear end fascia assembly) can be mounted to the fascia assembly 10 and properly oriented. This mounting and aligning may be done manually, but it is preferred to use the methods disclosed in pending International Patent Application No. WO 99/21748. The positioning mold of the above-mentioned application may be used in conjunction with a carrier panel to orient and fix the exterior visible components, which include structures such as the headlamps and the grill. Also, the fascia panel may be provided with positioning features in accordance with the teachings of the above-mentioned application so that the exterior visible components are properly oriented without the use of the carrier panel and then are secured to a carrier panel that is part of the partially completed vehicle during installation of the fascia assembly 10.

It should be understood that the method of the present invention may be practiced without using the teachings of the above-mentioned application. That is, one could form a fascia assembly in accordance with the broad teachings of the present invention and then deliver the same to the vehicle manufacturer, who in turn then mounts the fascia assembly to a partially completed vehicle and thereafter secures the exterior visible components in place. However, it is preferred to construct and ship the entire end module assembly with

WO 01/12411

PCT/CA00/00954

the fascia assembly formed in accordance with the teachings of the present invention and the exterior visible components mounted and aligned in accordance with the teachings of the above-mentioned application.

Fig. 8 shows another fascia assembly 100 constructed by the method of the present invention. The fascia assembly 100 of Fig. 8 has an exterior fascia panel 102 similar to fascia panel 12 and a pair of rigid lamp receiving cans 104, 106 connected on opposing lateral sides of the fascia panel 12. The lamp cans 104, 106 are made of a rigid material, such as ABS or a glass-filled thermoplastic, and are each configured to have the components of a vehicle head lamp mounted therein (i.e., the bulb, reflective backing, transparent cover, etc.) for connection to the electrical system of the vehicle during assembly. The material for the lamp cans 104, 106 is used to protect the lamp components from damage during vehicle operation and to facilitate heat dissipation. Although the lamp cans 104, 106 illustrated have straight side, top and bottom walls, the shape of the cans 104, 106 may take any desired configuration.

To mold the fascia assembly 100, a two-piece injection molding die assembly 110, shown in Fig. 10, is used. Die assembly 110 has two die portions 112, 114 that have interior surfaces 116, 118 that cooperate to form a die cavity 120. The die portions 112, 114 each have a passageway 122, 124 formed therethrough that communicates with gates 126, 128 and opens to the interior surfaces 116, 118.

To mold the fascia assembly 110, the die portions 112, 114 are brought together into their sealed, operative positions (as shown in Fig. 10) and the die cavity 120 is vacuumed. Then, gate 126 is opened to inject a first molten material into the die cavity 120 through passageway 122. The first molten material fills most of the die cavity 120 and forms the fascia panel 102 when solidified. A portion of the first molten material partially fills the area of the die cavity indicated at 130 to provide the panel 102 with a connecting portion 132. Then, gate 126 is closed and gate 128 is opened to inject a second molten material into the die cavity 120 through passageway 124. This second molten material fills the remainder of the die cavity 120 and forms the lamp receiving can 106. A portion of this second molten material fills the remainder of the area indicated at 130 to provide the lamp can 104 with a connecting portion 134. The assembly 100 is then solidified so that the connecting portions 132, 134 are solidified to and interconnected and the assembly 100 is removed from the mold.

As with fascia assembly 10, interlocking structures 136 may be used in fascia assembly 100 to enhance the connection between the connecting portions 132, 134. These interlocking structures 136 may be mold inserts or driven into the connecting portions 132, 134 after solidification.

It should be understood that Fig. 10 is a cross-section of the mold assembly 110



WO 01/12411

PCT/CA00/00954

Each energy absorbing structure 306 has a first connecting structure 308 molded and solidified to connecting portion 310 of the fascia panel 302. This may be achieved by a two-shot molding operation similar to the ones discussed above or by molding the panel 302 at one molding station and molding the absorbing structures 306 to the solidified panel

5 302 at another station. Then, after the panel 302 and absorbing structures 306 have been molded and connected together, the bumper beam 304 is molded and solidified so as to interconnect connecting portions 312 from the absorbing structure to connecting portions 314 of the bumper beam 304. It can be appreciated that the operation can be reversed by molding the panel 302 last instead of the bumper beam 304.

10 It can thus be seen that the objectives of the present invention have been fully and effectively accomplished. It is to be understood, however, that the foregoing specific embodiments have been provided for the purpose of illustrating the principle of the present invention and are not intended to be limiting. To the contrary, the present invention is intended to cover all modifications, alterations, and substitutions within the scope of the

15 appended claims.

WO 01/12411

PCT/CA00/00954

## WHAT IS CLAIMED:

1. A method for forming a fascia assembly that is to be mounted on a front or rear end of a partially completed motor vehicle, comprising:
  - molding and solidifying a molten first material so as to form an exterior fascia panel having a first connecting portion integrally molded therewith, said fascia panel being configured to constitute a portion of a vehicle body assembly when said fascia assembly is mounted on the front or rear end of the partially completed vehicle; and
  - molding and solidifying a molten second material so as to form a fascia assembly component having a second connecting portion integrally molded therewith with said second connecting portion of said fascia assembly component being molded and solidified to said first connecting portion of said exterior fascia panel in an interconnected relationship such that said connecting portions cooperate to interconnect said exterior fascia panel and said fascia assembly component together for subsequent transport and mounting to the partially completed vehicle.
2. A method according to claim 1, wherein molding and solidifying said molten second material so as to form said fascia assembly component includes molding and solidifying said molten second material so as to form a lamp receiving structure.
3. A method according to claim 2, wherein molding and solidifying said molten second material so as to form a lamp receiving structure includes molding and solidifying said molten second material so as to form a pair of lamp receiving cans that are spaced apart from one another in a transverse direction of said fascia assembly, each of said lamp receiving cans being constructed and arranged to allow a lamp bulb to be mounted therein and electrically connected to an electrical system of the motor vehicle and to allow a lens to be mounted in covering relation with respect to said lamp bulb when said fascia assembly is mounted to the front or rear end of the vehicle.
4. A method according to claim 1, wherein molding and solidifying said first molten material so as to form said fascia panel includes forming a grill receiving opening in said fascia panel and wherein molding and solidifying said molten second material so as to form said fascia assembly component includes molding and solidifying said molten second material so as to form a grill opening reinforcement structure that extends transversely with respect to said fascia panel, said grill opening reinforcement structure being constructed and arranged to have a grill mounted thereto.
5. A method according to claim 4, wherein molding and solidifying said molten second material so as to form said fascia assembly component includes molding and solidifying said molten second material so as to form a pair of lamp receiving cans that are spaced apart from one another in a transverse direction of said fascia assembly on opposing sides of said grill opening reinforcement structure, each of said lamp receiving

WO 01/12411

PCT/CA00/00954

cans being constructed and arranged to allow a lamp bulb to be mounted therein and electrically connected to an electrical system of the motor vehicle and to allow a lens to be mounted in covering relation with respect to said lamp bulb when said fascia assembly is mounted to the front or rear end of the vehicle.

- 5 6. A method according to claim 1, wherein molding and solidifying said molten second material so as to form said fascia assembly component includes molding and solidifying said molten second material so as to form a collapsible impact absorbing structure, said impact absorbing structure being constructed and arranged to be operatively connected to a frame of the motor vehicle and to collapse when said fascia panel impacts
- 10 an object during an automotive collision such that said absorbing structure absorbs at least a portion of the energy of the impact and prevents the absorbed portion of energy from being transmitted to the frame.
7. A method according to claim 6, wherein said collapsible impact absorbing structure is molded and solidified so as to integrally mold a third connecting portion with said
- 15 collapsible impact absorbing structure, and wherein said method further comprises:
- molding and solidifying a molten third material so as to form a bumper beam having a fourth connecting portion molded and solidified to the third interconnecting structure of said impact absorbing structure in an interconnected relationship wherein said connecting portion of said bumper beam and said third connecting portion of said
- 20 collapsible impact absorbing structure interconnect said bumper beam and said impact absorbing structure together, said third material having a greater rigidity than either of said first and second materials when solidified.

100694544 02.1507

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
22 February 2001 (22.02.2001)

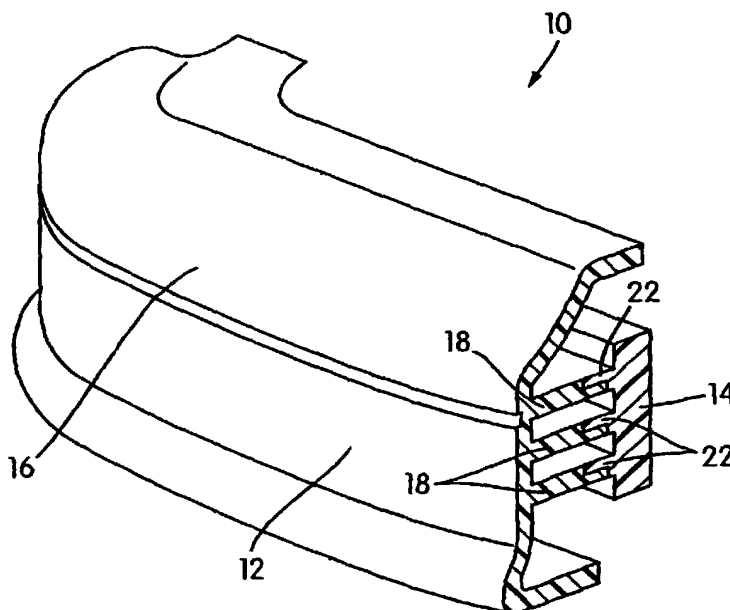
PCT

(10) International Publication Number  
**WO 01/12411 A1**

- (51) International Patent Classification<sup>7</sup>: **B29C 45/16**, B60R 19/18 (74) Agent: **IMAI, Jeffrey, T.**; Magna International Inc., 337 Magna Drive, Aurora, Ontario L4G 7K1 (CA).
- (21) International Application Number: PCT/CA00/00954 (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
- (22) International Filing Date: 16 August 2000 (16.08.2000)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data: 60/148,692 16 August 1999 (16.08.1999) US (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).
- (71) Applicant (*for all designated States except US*): **DECOMA INTERNATIONAL CORP.** [CA/CA]; 50 Casmir Court, Concord, Ontario L4K 4J5 (CA).
- (72) Inventor; and
- (75) Inventor/Applicant (*for US only*): **YUSTICK, Robert, F.** [US/US]; 2781 Pine Heights Drive, West Bloomfield, MI 48324 (US).
- Published:**  
— With international search report.  
— Before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments.

[Continued on next page]

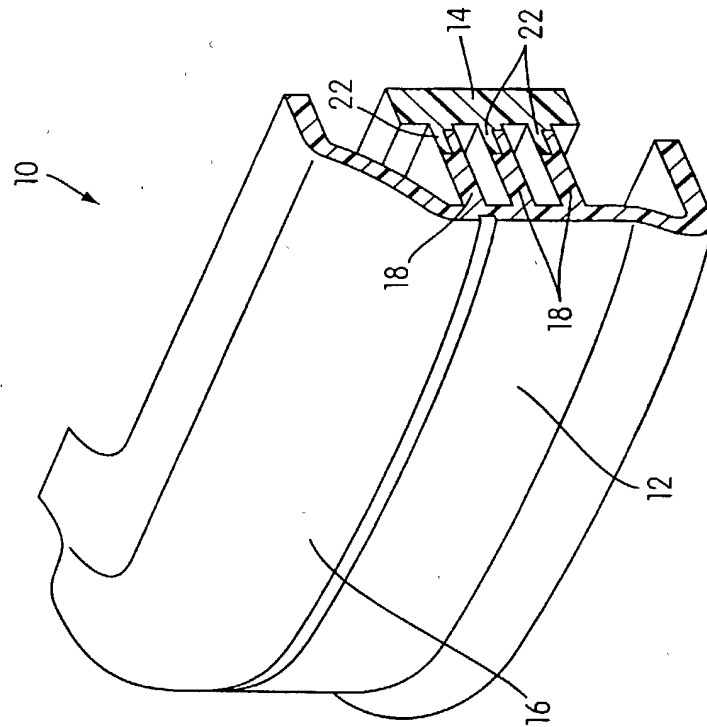
(54) Title: METHOD FOR FORMING A FASCIA ASSEMBLY FOR A MOTOR VEHICLE



(57) Abstract: The present application discloses a method for forming a fascia assembly that is to be mounted on a front or rear end of a partially completed motor vehicle. The method comprises (1) molding and solidifying a molten first material so as to form an exterior fascia panel having a first connecting portion integrally molded therewith, and (2) molding and solidifying a molten second material so as to form a fascia assembly component having a second connecting portion integrally molded therewith and molded and solidified to the connecting portion of the exterior fascia panel in an interconnected relationship.



WO 01/12411 A1





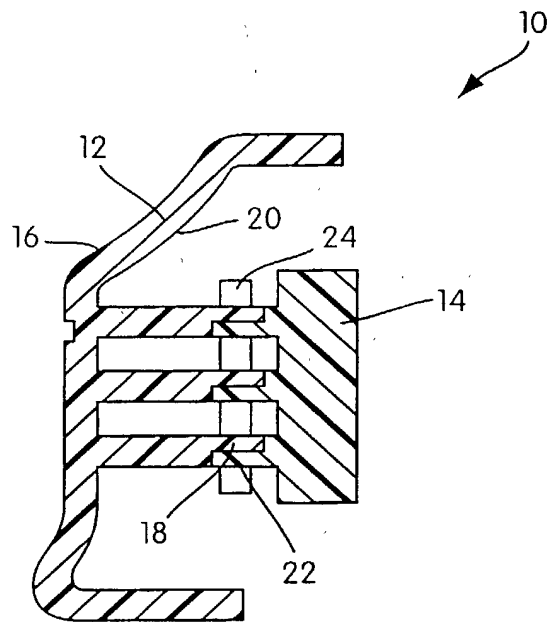


FIG. 2

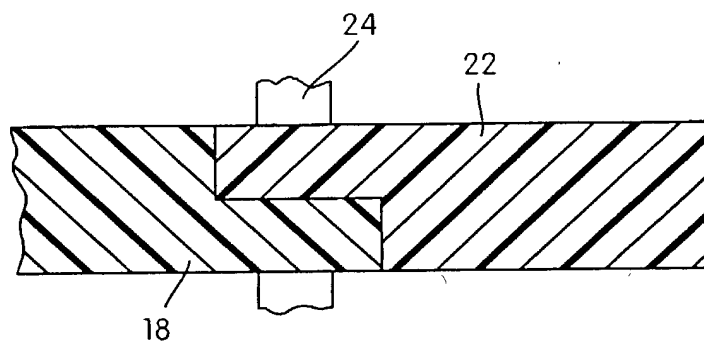


FIG. 3

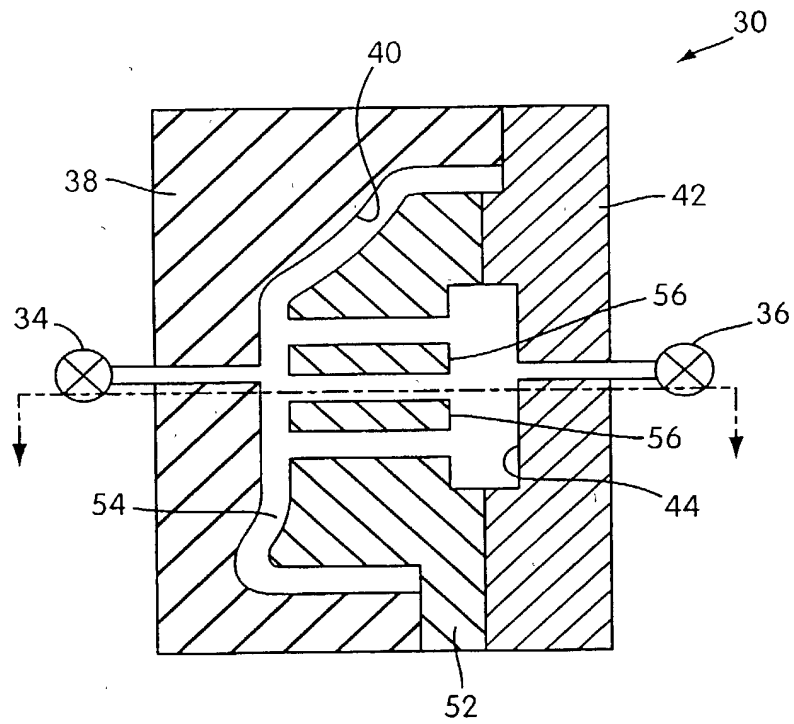


FIG. 4

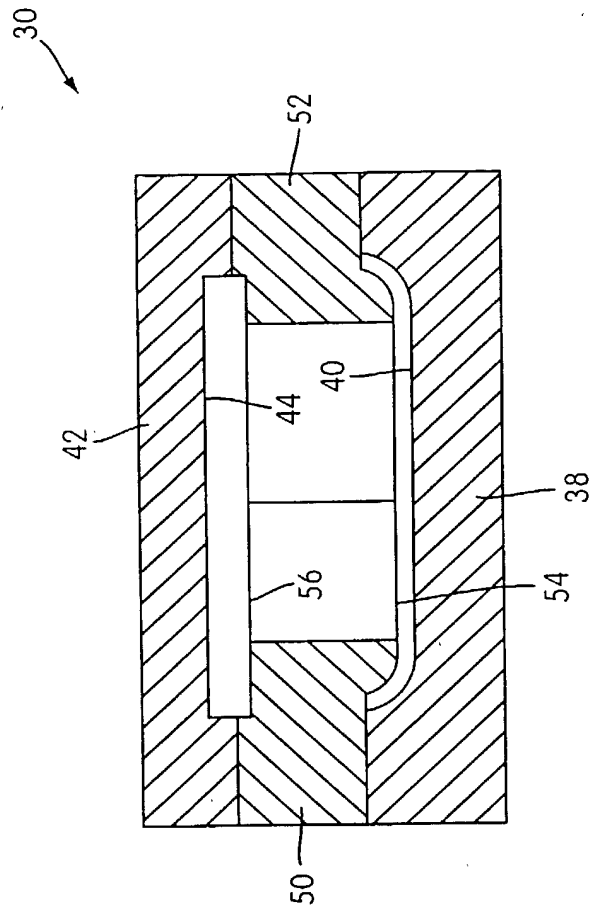


FIG. 5

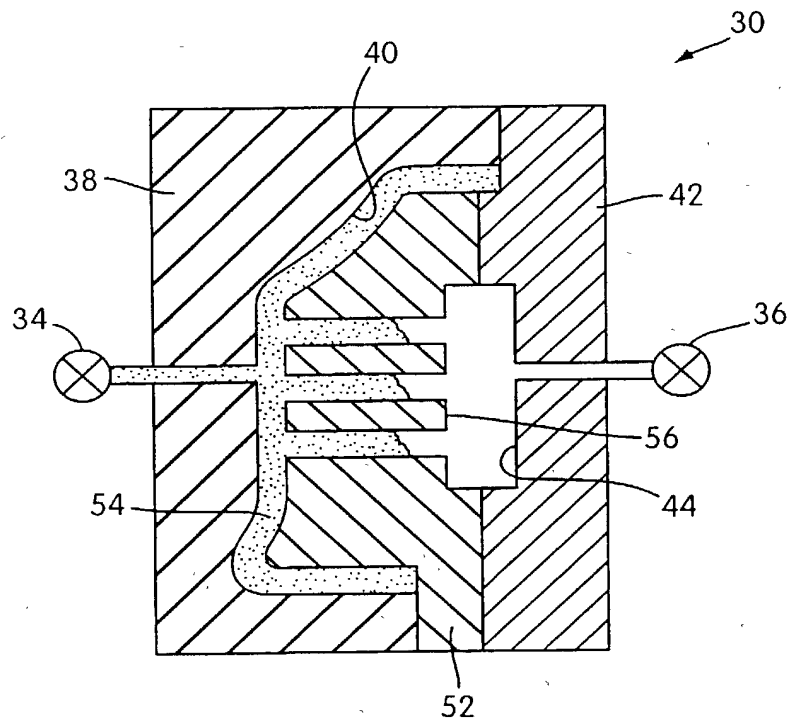


FIG. 6

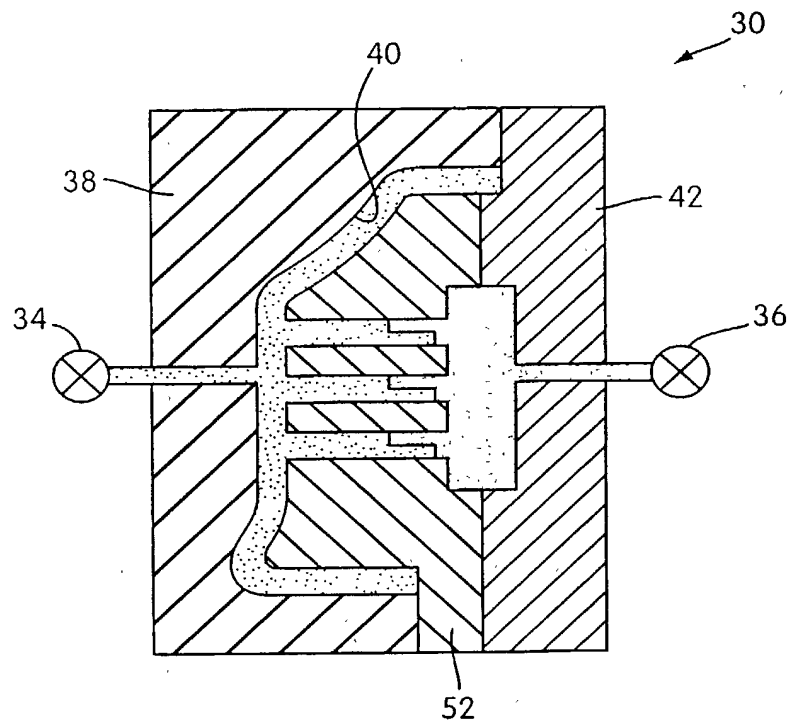


FIG. 7

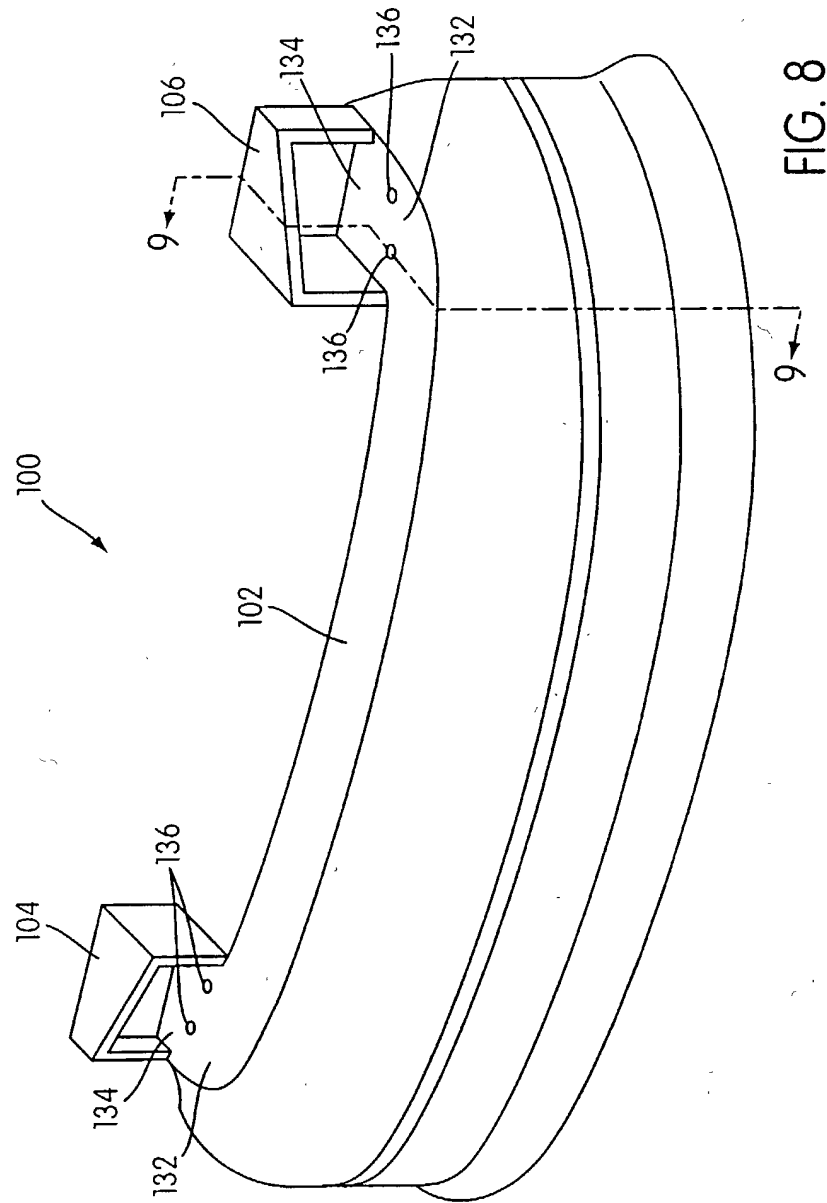


FIG. 8

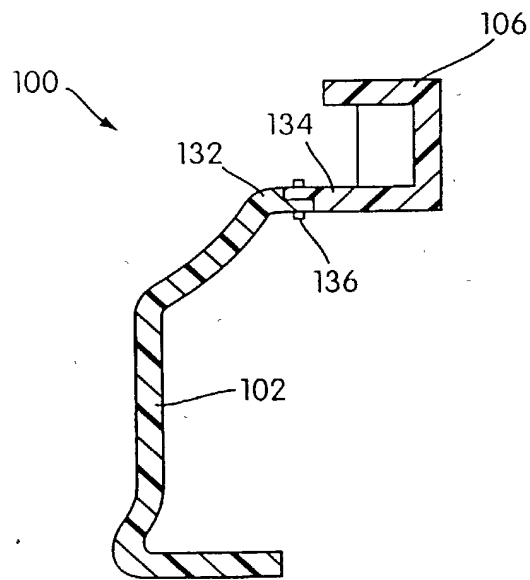


FIG. 9



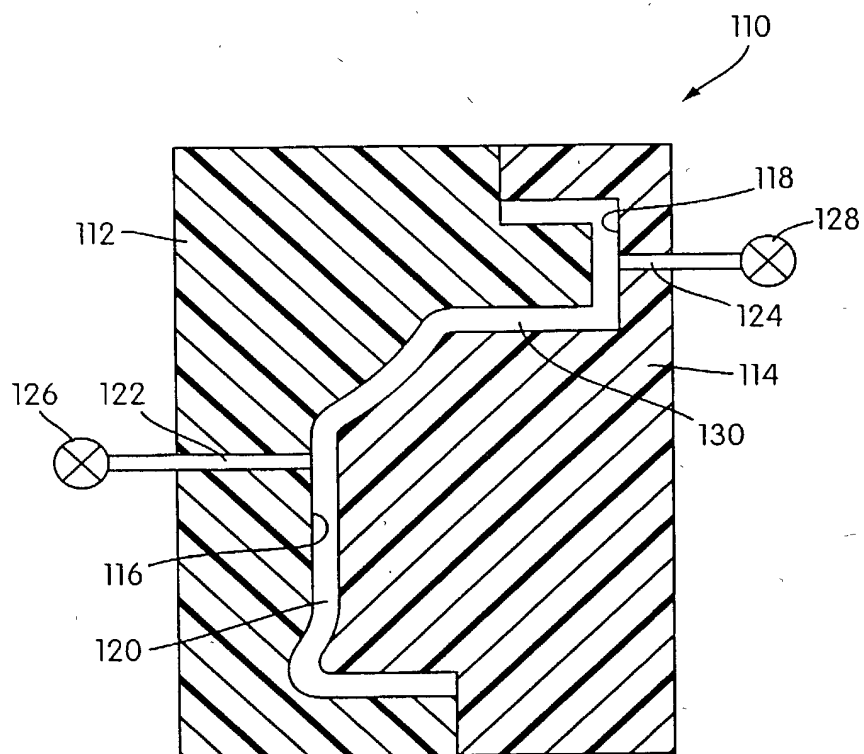


FIG. 10

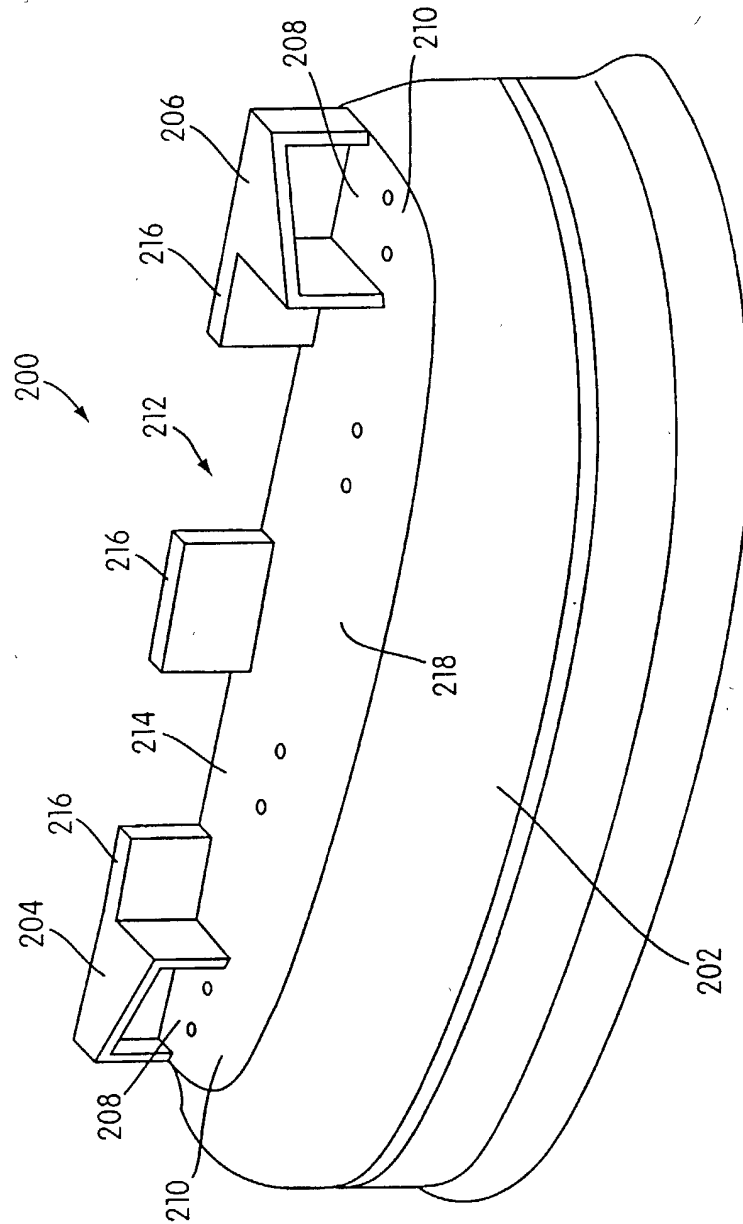


FIG. 11

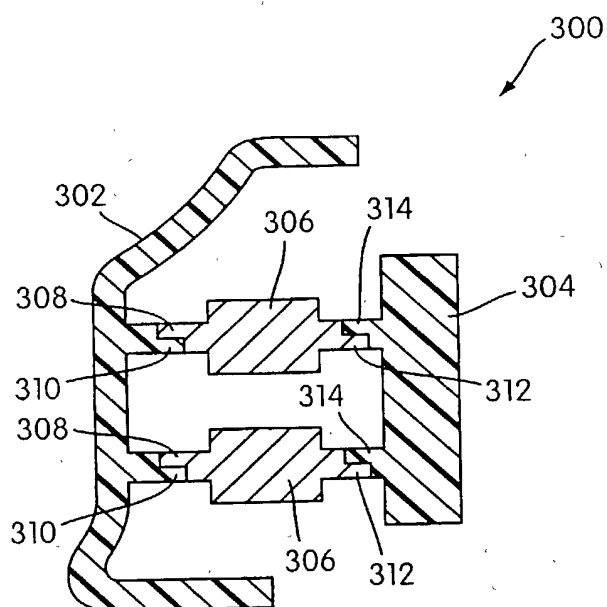


FIG. 12

10069184 1021502

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled  
**Method For Forming A Fascia Assembly For A Motor Vehicle**

the specification of which

(check one)

☐ is attached hereto.

☒ was filed on August 16, 2000 as United States Application No. or PCT International Application Number PCT/CA 00/00954  
and was amended on \_\_\_\_\_

(if applicable)

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, Section 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, Section 119(a)-(d) or Section 365(b) of any foreign application(s) for patent or inventor's certificate, or Section 365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate or PCT International application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application(s)			Priority Not Claimed
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	<input type="checkbox"/>
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	<input type="checkbox"/>
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	<input type="checkbox"/>

---

(Application Serial No.)

---

(Filing Date)

---

(Application Serial No.)

---

(Filing Date)

I hereby claim the benefit under 35 U. S. C. Section 120 of any United States application(s), or Section 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. Section 112, I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, C. F. R., Section 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application:

---

(Application Serial No.)

---

(Filing Date)

---

(Status)  
(patented, pending, abandoned)

---

(Application Serial No.)

---

(Filing Date)

---

(Status)  
(patented, pending, abandoned)

---

(Application Serial No.)

---

(Filing Date)

---

(Status)  
(patented, pending, abandoned)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

David J. SIMONELLI

36,680

Jay S. PARANJPE

45,486

10059134 021502

Send Correspondence to: Mr. Robin W. Asher  
Clark Hill, P.L.C.  
500 Woodward Avenue, Suite 3500  
Detroit, Michigan, 48226-3435

Direct Telephone Calls to: (name and telephone number)  
Robin W. Asher Phone: (313) 965-8300

Full name of sole or first inventor

Robert E. YUSTICK

Sole or first inventor's signature

Date

1/2/2002

Residence

West Bloomfield, MichiganMI.

Citizenship

United States of America

Post Office Address

2781 Pine Heights Drive, West Bloomfield, Michigan, 48324, U.S.A.

Full name of second inventor, if any

Second inventor's signature

Date

Residence

Citizenship

Post Office Address